

Work Order ID 50465

July 10, 2009 1:30:23 PM



Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 7/06/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/06/09

Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 09-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 [1]Dwg Rev: B [1]Prog Rev: B [1]2-
Deburr if necessary

B 9-7-22

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-7-22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 02/07/22

contin
+20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July 10, 2009 1:30:23 PM



Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

8 09/09/03

20

0

Brake NC

Form as per Dwg D3637

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

2 8 09/09/03

counters
x20

4

Quality Control

150

0.00



Small Fab

Small Fab

Memo

0.00

8 09/09/09 20

Small Fab

1- drill holes as per dwg using DT8979 2- c/sink holes as per dwg 3-deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50465

September 9, 2009 1:36:57 PM



Page 3

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Setup Start



Revision ID: B

Stop



Item Name: Bracket

Start Date: 07/06/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/06/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 => 8/07/09/09 0.00				count (750)	✓		
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 => 11/09/09/15 0.00				(x20)	✓		
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 => 8/07/09/15 0.00				count (x20)	✓		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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September 9, 2009 1:36:57 PM



Page 4

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Revision ID: B

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Item Name: Bracket

Start Date: 07/06/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/06/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location <u>244A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

u 09.09.16

Picklist Print

July 10, 2009 1:30:23 PM

Page 1

Work Order ID: 50465



Parent Item: D3637-3RevB



Parent Item Name: Bracket

Start Date: 7/06/09

Required Date: 7/06/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	52.6300	0.2821			



2024-T3 .050 sheet



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

111381

52.63

52.63

111381 189-7-22

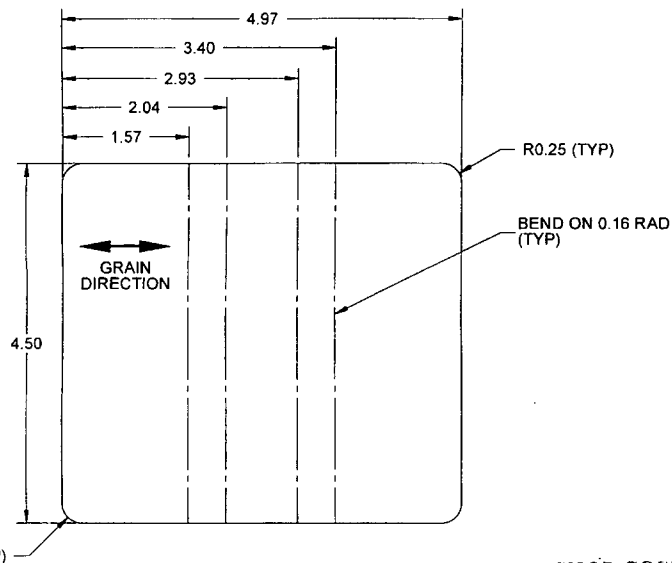
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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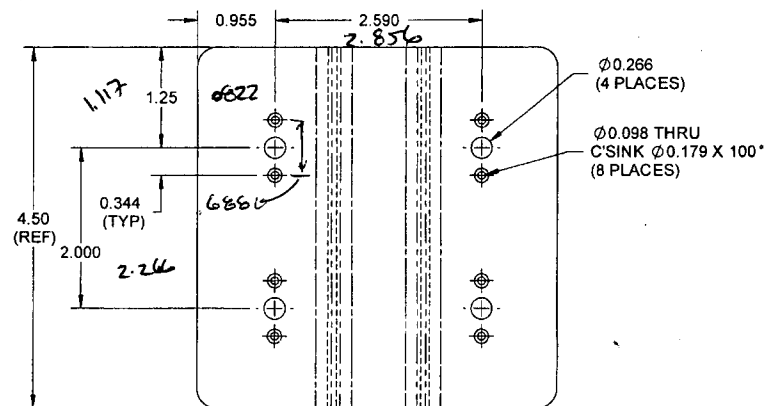
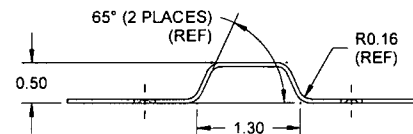
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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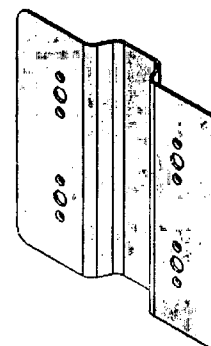
D3637-3F FLAT PATTERN



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50465.

MF 09-07-15



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PE	DRAWING NO.	REV. B
MFG. APPR.	CD	D3637	SHEET 3 OF 3
APPROVED	MF	TITLE	SCALE
DE APPR.	MF	BRACKET	2:3
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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